

# Work Order ID 121159

July-10-14 7:56:29 AM

*Reprint*  
\*121159\*

Page 1

Item ID: D4434-3

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bracket

Start Date: 6/16/14

Start Qty: 16.00

\*16\*

Cust Item ID:

Required Date: 6/16/14

Req'd Qty: 16.00

\*16\*

Customer:

Reference:

Approvals:

Process Plan: *V*

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4434

C

100

0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

(16) mm 14/07/15

110

0.00

\*110\*

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

(16) mm 14/07/15

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Item ID: D4434-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Bracket  
 Start Date: 6/16/14 Start Qty: 16.00 **\*16\*** Cust Item ID:  
 Required Date: 6/16/14 Req'd Qty: 16.00 **\*16\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 DAS 27 9-39 4/7/15				16			
130 <b>*130*</b> Brake NC Brake NC	Bend as per dwg  Memo	0.00 0.00		DAS 30 9-89		16			14/07/15
150 <b>*150*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 DAS 27 9-89 4/7/16				16			

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Item ID: D4434-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Bracket  
 Start Date: 6/16/14 Start Qty: 16.00 **\*16\*** Cust Item ID:  
 Required Date: 6/16/14 Req'd Qty: 16.00 **\*16\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 <b>*160*</b> HandFinish HandFinishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				16	76/147/16		
170 <b>*170*</b> QC Quality Control	QC7-Inspect Chemical Conversion Coat  Memo	0.00  0.00				16			
180 <b>*180*</b> Packaging Packaging	Identify as per dwg & Stock Location <u>80375</u>  Memo	0.00  0.00				16x	147-18		

DAS  
26  
9-89

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**\*121159\***

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Item ID: D4434-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Bracket  
Start Date: 6/16/14 Start Qty: 16.00 **\*16\*** Cust Item ID:  
Required Date: 6/16/14 Req'd Qty: 16.00 **\*16\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
<b>*190*</b>									
QC	Memo	0.00							
Quality Control									

MLJ 14-07-21

① 14-7-18

# Picklist Print

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Page 1  
T

Work Order ID: 121159

**\*121159\***

Parent Item: D4434-3

**\*D4434-3\***

Parent Item Name: Bracket

Start Date: 6/16/14

Required Date: 6/16/14

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A 12.03.06 per REV.B DD verified by:EC  
13.04.01 AS PER D4434 REV.C DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased			No			100	sf	127.7900	0.55	10	

**\*M6061T6S 040\***

6061-T6 .040 Sheet

**\*\***

mm 17/07/15

Location

Loc Qty

Loc Code

MAT021

127.79

m128422

49.79

m129584

78

9.3

121159

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>
<b>Description:</b> Bracket		<b>Part Number:</b> D4434-3
<b>Inspection Dwg:</b> D4434	<b>Rev:</b> C	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	0.098	/		V- Skm-01	
Ø0.177	+0.005/-0.001	0.179	/		T- Skm-06	
0.34	+/-0.030	0.34	/			
0.45	+/-0.030	0.45	/			
0.55	+/-0.030	0.55	/			
1.00	+/-0.030	1.00	/			
6.00	+/-0.030	6.00	/			
10.88	+/-0.030	10.88	/			
11.49	+/-0.030	11.49	/			
9.70	+/-0.030	9.70	/			
6.45	+/-0.030	6.45	/			
1.00	+/-0.030	1.00	/			
0.90	+/-0.030	0.90	/			
1.790	+/-0.010	1.790	/			
2.590	+/-0.010	2.590	/			
3.390	+/-0.010	3.390	/			
4.417	+/-0.010	4.417	/			
5.12	+/-0.030	5.12	/			
5.817	+/-0.010	5.817	/			
6.45	+/-0.030	6.45	/			
6.32	+/-0.030	6.32	/			
5.59	+/-0.030	5.59	/			
4.49	+/-0.030	4.49	/			
3.16	+/-0.030	3.16	/			
0.040	+/-0.010	0.039	/			

<b>Measured by:</b> mm	<b>Audited by:</b> DAS 27	<b>Preliminary Approval:</b>
<b>Date:</b> 17/07/15	<b>Date:</b> 14/11/15	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	12.03.08	New Issue	KJ	
B	14.04.14	Dimensions updated per Dwg Rev C	KJ	

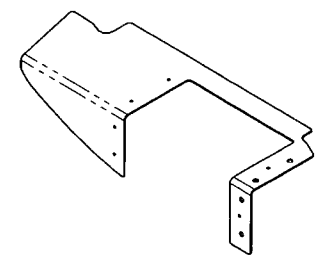
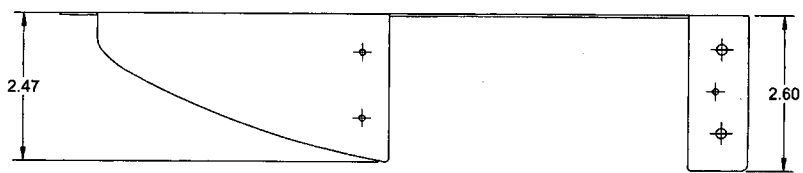
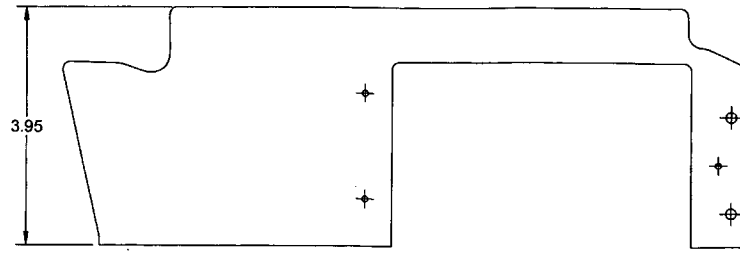
8 7 6 5 4 3 2 1

D

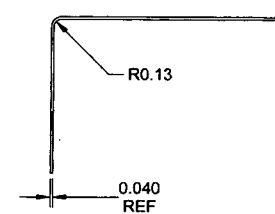
C

B

A



W/0121159



**D4434-3 BRACKET**

**RELEASED**  
2014-03-31

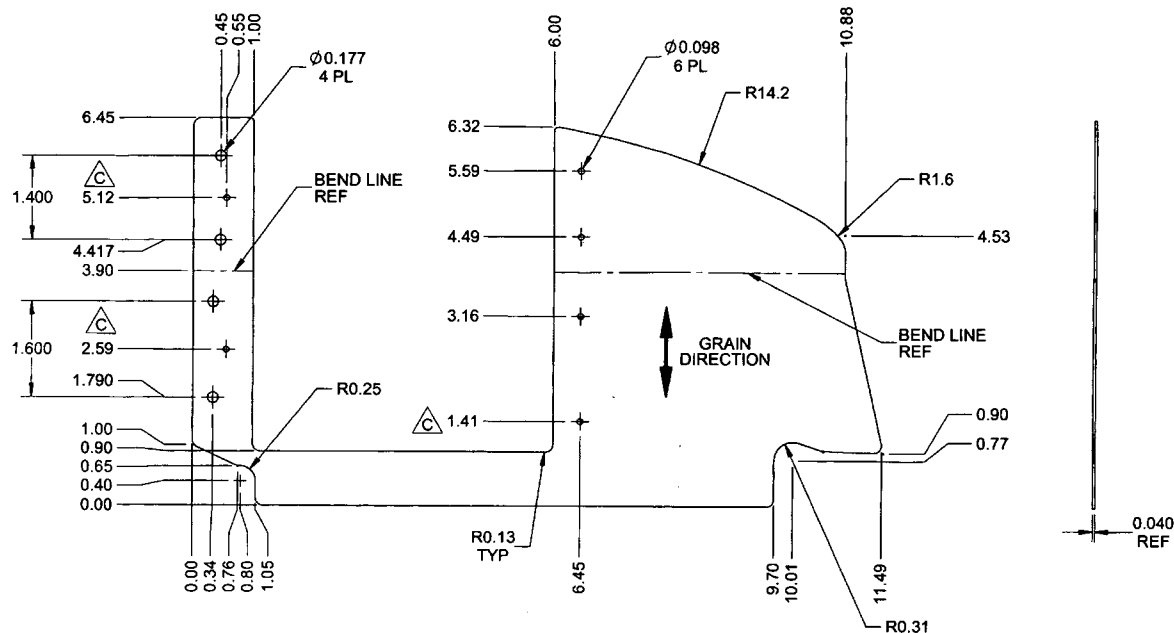
**NOTES:**

- 1) MATERIAL: MAKE FROM D4434-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.14 lbs

APPROVED

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DC	DRAWING NO.	REV. C
MFG. APPR.	DD	<b>D4434</b>	SHEET 8 OF 15
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	<b>COVER ASSEMBLY</b>	NTS
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8 7 6 5 4 3 2 1



# **D4434-3F FLAT PATTERN**

## **NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.14 lbs

APPROVED

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DC	DRAWING NO.	REV. C
MFG. APPR.	DD	<b>D4434</b>	SHEET 9 OF 15
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	<b>COVER ASSEMBLY</b>	NTS
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2014-03-31